

Work Order ID 87316

July-13-12 11:51:58 AM

87316

Page 1

Item ID: D3901-1

Accept

N9000040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Bar

Start Date: 7/06/12 Start Qty: 4.00

4

Cust Item ID:

Required Date: 8/10/12 Req'd Qty: 4.00

4

Customer:

Reference:

Run Start ***NR1***

Approvals: Process Plan: MLJ

Date: 12/07/13

Tooling:

Date:

Stop ***NR2***

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3901

C

0.00

P0 12/08/13

4

Ø

0.00

100

Cold Saw

Memo

Hyd Mech

Cut blanks at 54.75"

0.00

110

110

HAAS 1

HAAS CNC vertical machine #1

Memo

1-Mill as per folio FB090 & dwg D3901,

FOLIO REV: 00

DWG REV: 00

2-Deburr as required

0.00

B.A 12/08/13

4

Ø

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 87316

87316

Page 2

July-13-12 11:51:58 AM

Item ID: D3901-1

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Bar

Stop ***NS2***

Start Date: 7/06/12

Start Qty: 4.00

4

Cust Item ID:

Required Date: 8/10/12

Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC2- Inspect parts off machine FAI/FAIB

0.00

B.A 12/08/13

4

0

120

QC

Memo

0.00

Quality Control

EXTRA MATERIAL WILL BE CUT ON ASSEMBLY

130

QC8- Inspect parts - second check

0.00

SL 12-08-15

(4)

130

QC

Memo

0.00

Quality Control

EXTRA MATERIAL WILL BE CUT ON ASSEMBLY

140

Identify as per dwg & Stock Location: W/A

0.00

140

Packaging

Memo

0.00

Packaging

(4)

12-8-15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

July-13-12 11:51:57 AM

Page 1

Work Order ID: 87316

Parent Item: D3901-1

Parent Item Name: Bar

Start Date: 7/06/12

Required Date: 8/10/12

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP RevA: New issue DD verified by:EC
verified by:JLM

IPP RevB: Now on cnc JFS 12/02/13

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304B0.250x0.500 304 BAR .250 x .500		Purchased	No			100	f	566.4540	4.513	19.002105			

30 12/08/13

Location	Loc Qty	Loc Code
MAT050	566.454	
121216	142.08	
121547	63.904	
122008	360.47	

4.52 19.1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

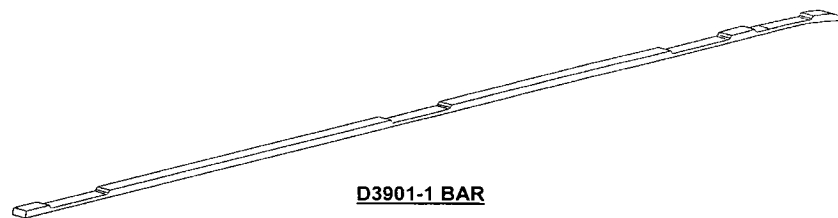
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

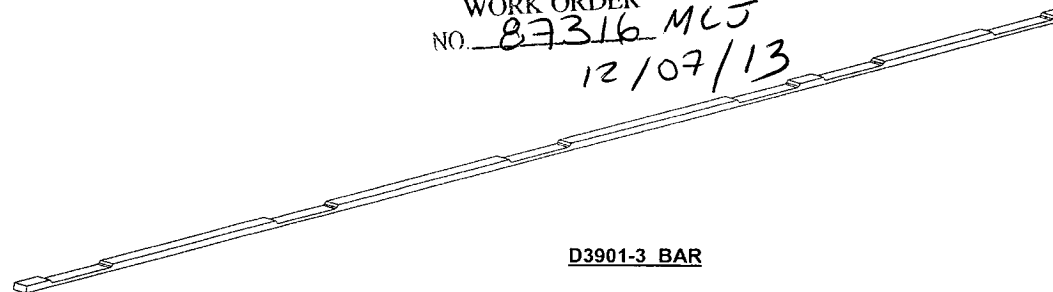
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

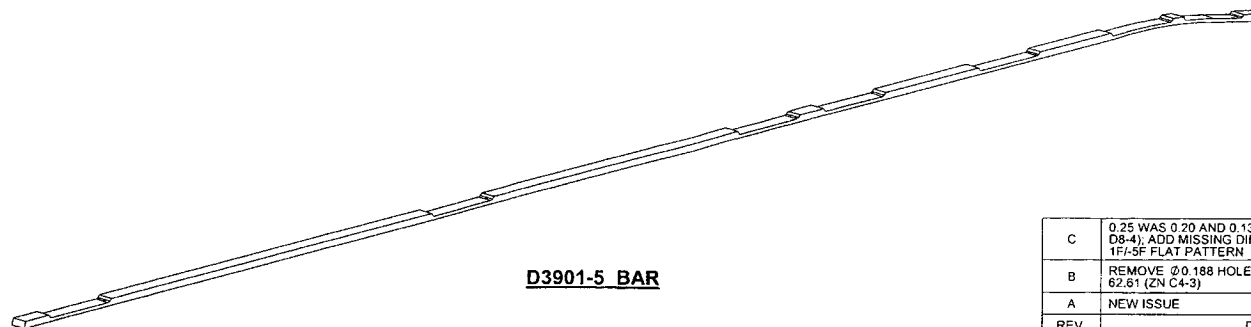
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 87316 MLJ
12/07/13



D3901-1 BAR



D3901-3 BAR

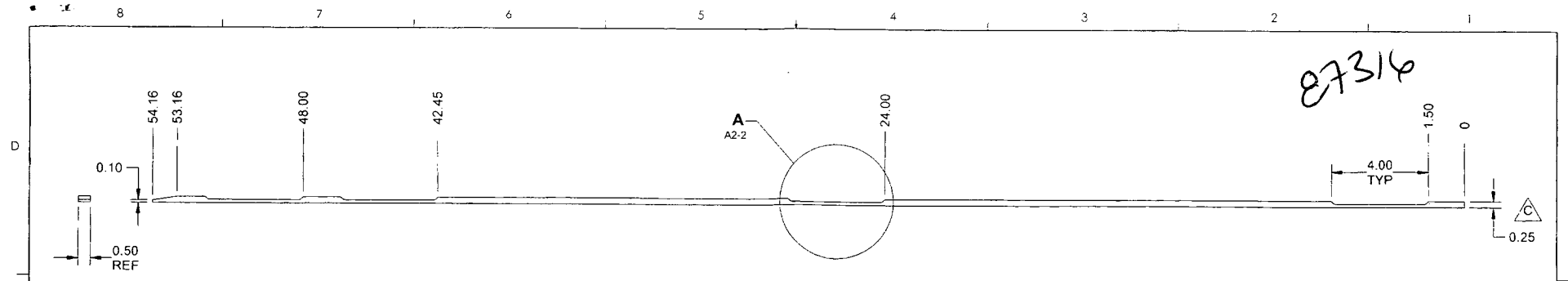


D3901-5 BAR

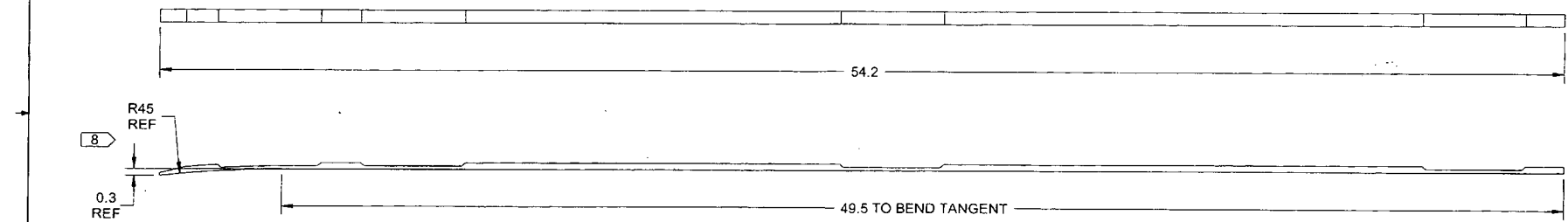
RELEASED
2012-06-27
[Signature]

C	0.25 WAS 0.20 AND 0.130 WAS 0.080 (ZN B2-2, B1-2, B1-3, D8-4); ADD MISSING DIMENSIONS (ZN C5-3); ADD D3901, 1F-5F FLAT PATTERN	RF	12.01.24
B	REMOVE Ø0.188 HOLES FROM D3901-1/-3/-5; 62.12 WAS 62.61 (ZN C4-3)	RF	09.06.30
A	NEW ISSUE	RF	09.03.30
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE USA, INC. KENT, WA	
DRAWN	RF		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>[Signature]</i>	D3901	SHEET 1 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	BAR	NTS
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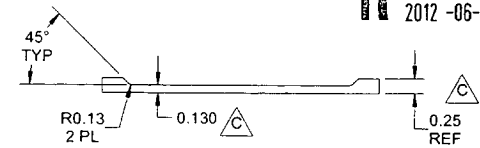
87316



D3901-1F BAR FLAT PATTERN



D3901-1 BAR
(MAKE FROM D3901-1F)



DETAIL A
TYP. SCALE 2X

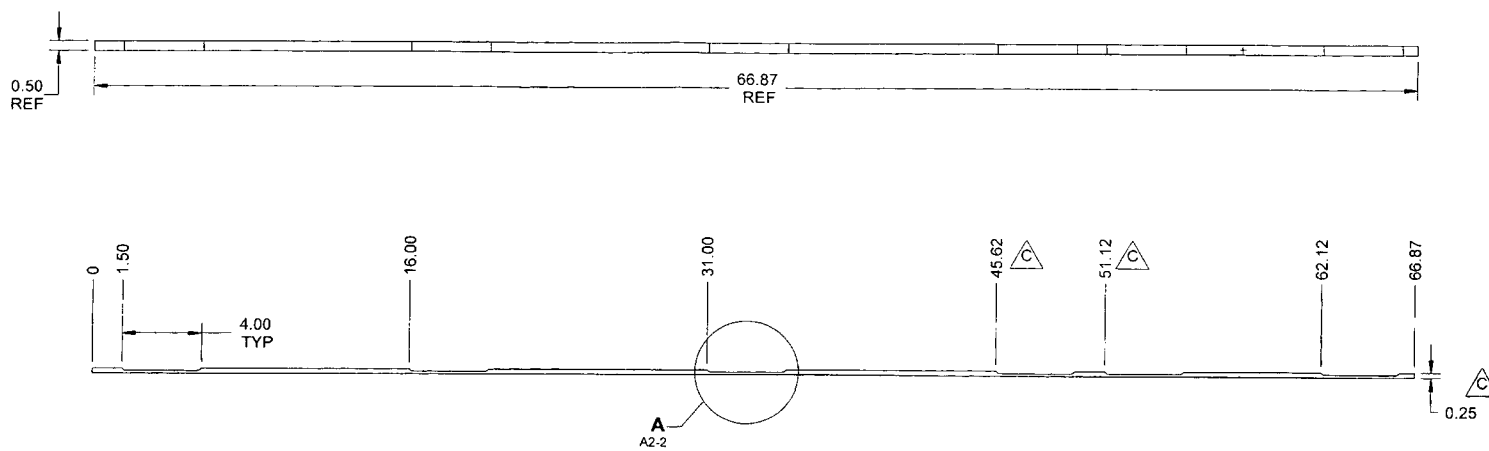
RELEASED
2012-06-27

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL BAR, 0.50 THICK (REF. DART SPEC. M304B)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 1.68 lbs
- 8) FORM TO FIT WEARPLATE

DESIGN		DART AEROSPACE USA, INC.	
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CHECKED	RF	DRAWING NO.	REV. C
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27316



D3901-3 BAR

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2012-06-27

NOTES:

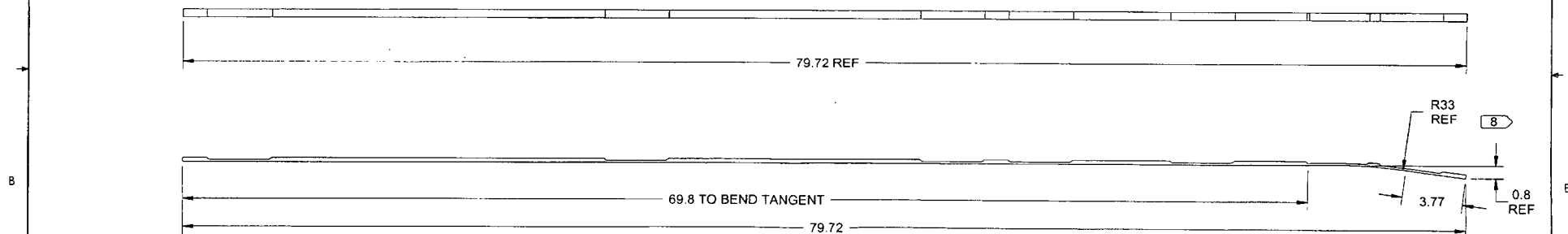
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL BAR, 0.50 THICK (REF. DART SPEC. M304B)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 2.01 lbs

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8731x



D3901-5F BAR FLAT PATTERN



**D3901-5 BAR
(MAKE FROM D3901-5F)**

RELEASED
2012-06-27

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL BAR, 0.50 THICK (REF. DART SPEC. M304B)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 2.40 lbs
- 8) FORM TO FIT WEARPLATE

DESIGN		RF		DART AEROSPACE USA, INC.	
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CHECKED		[Signature]		DRAWING NO.	REV. C
MFG. APPR.		[Signature]		D3901	SHEET 4 OF 4
APPROVED		[Signature]		TITLE	SCALE
DE APPR.		[Signature]		BAR	NTS
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